

Work Order ID 67170

Wednesday, March 09, 2011 12:53:38 PM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-03-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9527	rev A
IIN-D206-559	rev K

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

W/ JG for BG 11-3-16 (4)
11 23 16 (4)

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

160/3/16 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D206-559-013

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Revision ID:

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Item Name: Bearpaw

Start Date: 3/9/2011 Start Qty: 4.00

Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

w 11 03 16 (4)

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: FGP12

Rev B

11/3/12

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/17
ME
11-03-16

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Picklist Print

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Page 1

Work Order ID: 67170

Parent Item: D206-559-013

Parent Item Name: Bearpaw



Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:J 04.02.17 Blank size changed KJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	670.0000	12	48			

Location	Loc Qty	Loc Code
357	100	
116786	100	
ST358	570	
116419	270	
116704	300	

116419

AN4-20A Bolt	Purchased	No				160	Each	429.0000	12	48			
---------------------	-----------	----	--	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST359	429	
104016	29	
115936	200	
116419	200	

104016 29
 115936 200

11/3/15
 (4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 67170

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No

160 Each

30.0000

24

96



Washer



1117065

Handwritten signature

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2182B

Manufactured No

160

f

461.3681

2.5

10



Rubber Cushion



Handwritten signature

Location

Loc Qty

Loc Code

ST410

461.36811

63413

111.36811

66063

350

63413

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274

Manufactured No

160

Each

484.0000

12

48



Radius Block



Handwritten signature and date 3/13/16

Location

Loc Qty

Loc Code

ST010

484

61361

1

63990

6

65562

104

65757

250

66123

123

65562

Wednesday, March 09, 2011 12:53:47 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 67170

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

D2432
206 (24") Bearpaw

Manufactured No

160 Each

1.0000

2

8



65799

[Handwritten signature]

Location

Loc Qty

Loc Code

ST017

1

65302

1

D2438
Clamp

Manufactured No

160 Each

159.0000

6

24



[Handwritten signature]

Location

Loc Qty

Loc Code

ST456

159

64772

25

66064

79

66128

55

64772 10X
66064 9X

D2529
Washer

Manufactured No

160 Each

982.0000

12

48



[Handwritten signature]

Location

Loc Qty

Loc Code

ST016

982

64127

482

66953

500

64127

D2732
Rubber Extrusion

Manufactured No

160 f

505.7693

2.5

10



10/13/16 (4)

Location

Loc Qty

Loc Code

ST410

494.75

64283

494.75

ST412

11.019279

56516

11.019279

64283

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

Wednesday, March 09, 2011 12:53:47 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

Wednesday, March 09, 2011 12:53:47 PM

Work Order ID: 67170



Parent Item: D206-559-013



Parent Item Name: Bearpaw

Start Date: 3/9/2011

Required Date: 3/16/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

4,376.000

12

48



Nut



Ce 11/3/16 (4)

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

11/6/88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 REV. K OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 2 OR EARLIER
REF. TCCA STC: SH92-17
REF. FAA STC: SH1031NE

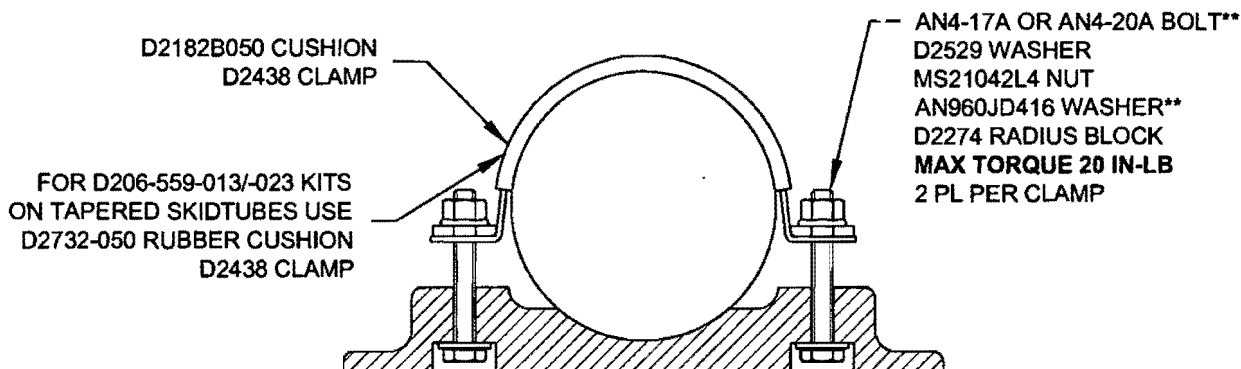
PURPOSE:

For D206-559-011/-013/-021/-023/-031/-033 bearpaw kits, the AN4 bolts specified were for installation with the aft skidtube wearshoe removed. Bolt lengths are increased to accommodate installation with the skidtube wearshoe installed, which is more practical.

CHANGE:

The parts list is updated as shown on sheet 2 of this service instruction, for bearpaw kits: D206-559-011 at CHG 007, D206-669-013 at CHG 006, D206-559-021 at CHG 008, D206-559-023 at CHG 007, D206-559-031 at CHG 002, and D206-559-033 at CHG 002.

Figure 4 of D206-559 and Figure 32-3 of ICA-D206-559 are amended as follows:



SHOP COPY...
RETURN TO...
ENGINEERING...
UNCONTROLLED...
SUBJECT TO AMENDMENTS...
WITHOUT NOTICE...
WORK ORDER...
NO. 67170
PL 11-03-9

USE AN4-17A BOLTS WITH AN AN960JD416 (OR NAS1149D0463J) WASHER IF INSTALLING BEARPAW ON 3.0" DIA. TUBE OR SMALLER. USE AN4-20A BOLTS WITH TWO AN960JD416 WASHERS IF INSTALLING BEARPAW ON TUBE LARGER THAN 3.0" DIAMETER (DART TUBE). ADDITIONAL AN960JD416 WASHERS MAY BE ADDED UNDER NUT TO ENSURE 2-4 THREADS IN SAFETY. IT IS ALSO ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS IF REQUIRED TO ENSURE BEARPAW IS HELD SECURELY.

FIGURE 4: TYPICAL CLAMPING DETAIL (D206-559)
FIGURE 32-3: TYPICAL CLAMPING DETAIL (ICA-D206-559)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED BY: <i>[Signature]</i> D. SHEPHERD (DE # 02)	
DATE: 10.06.30	
CERT. NO.: SH92-17	
ISSUE NO.: 7	

A	NEW ISSUE	CP	10.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. REV. A	
CHECKED	<i>[Signature]</i>	DSI 9527 SHEET 1 OF 2	
MFG. APPR.	N/A	TITLE SCALE	
APPROVED	<i>[Signature]</i>	BOLT CHANGE NTS	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.06.30	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

W/B 67170

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]
BY: D. SHEPHERD (DE # 02)

DATE: 10.06.30
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	<i>gp</i>	DART AEROSPACE LTD	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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